

54481 Deren

Work Order ID 53400

November 3, 2009 3:19:11 PM



Page 1

Item ID: DSK076

Accept



Setup Start



Revision ID: A

Stop



Item Name: D2891-1 TURNING DETAIL

Start Date: 03/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*Date: *07-11-3*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSK076

Rev A

100



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

Turn blank for as per Folio FA046

0.00

0.00

Ref 09-11-14

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

*Ref 09-11-14**(3)*

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

*Ref**(3)*

Work Order ID 53400

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Page 2

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Item Name: D2891-1 TURNING DETAIL

Start Date: 03/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban ☐ Location: *CWL**09.11.14*

140

0.00



QC21 - Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*09/12/10**MF**09-12-09*

Picklist Print

November 3, 2009 3:19:15 PM

Page 1

Work Order ID: 53400

Parent Item: DSK076RevA

Parent Item Name: D2891-1 TURNING DETAIL

Comments:

Start Date: 03/11/2009

Required Date: 16/11/2009

Start Qty: 10.00

Required Qty: 10.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

D6104-003RevB

Manufactured

No

Each

10.0000

10.0000



Round Billet, 17-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

52969

10

10

10.11.14

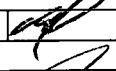
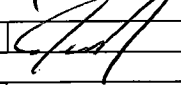
3



| | | | |
|--|--|---------------------|--------------------|
| DART AEROSPACE LTD | | Work Order: | 53400 |
| Description: Turning Detail for D2891-1 | | Part Number: | DSK076 |
| Inspection Dwg: DSK076 | | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

| | | | | Record Actual Dimensions | | | | |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | 5 |
| Lathe Section | | | | | | | | |
| A | 2.274 | 2.279 | | 2.279 | 2.279 | 2.279 | 2.279 | 2.279 |
| B | 3.702 | 3.722 | | 3.712 | 3.712 | 3.712 | 3.712 | 3.712 |
| C | 2.564 | 2.584 | | 2.574 | 2.574 | 2.574 | 2.574 | 2.574 |
| D | 0.718 | 0.738 | | .728 | .728 | .728 | .728 | .728 |
| E | 0.090 | 0.110 | | .100 | .100 | .100 | .100 | .100 |
| F | 2.464 | 2.484 | | 2.474 | 2.474 | 2.474 | 2.474 | 2.474 |
| G | 2.029 | 2.049 | | 2.039 | 2.039 | 2.039 | 2.039 | 2.039 |
| H | 2.964 | 2.984 | | 2.974 | 2.974 | 2.974 | 2.974 | 2.974 |
| I | 0.913 | 0.933 | | .923 | .923 | .923 | .923 | .923 |
| J | 0.022 | 0.042 | | .032 | .032 | .032 | .032 | .032 |
| K | 0.090 | 0.110 | | | | | | |
| L | | | | | | | | |
| M | | | | | | | | |
| N | | | | | | | | |
| O | | | | | | | | |
| P | | | | | | | | |

| | |
|---|-----------------------|
| Measured by:  | Date: 09.11.14 |
| Audited by:  | Date: 09.12.08 |
| Prototype Approval: | Date: |

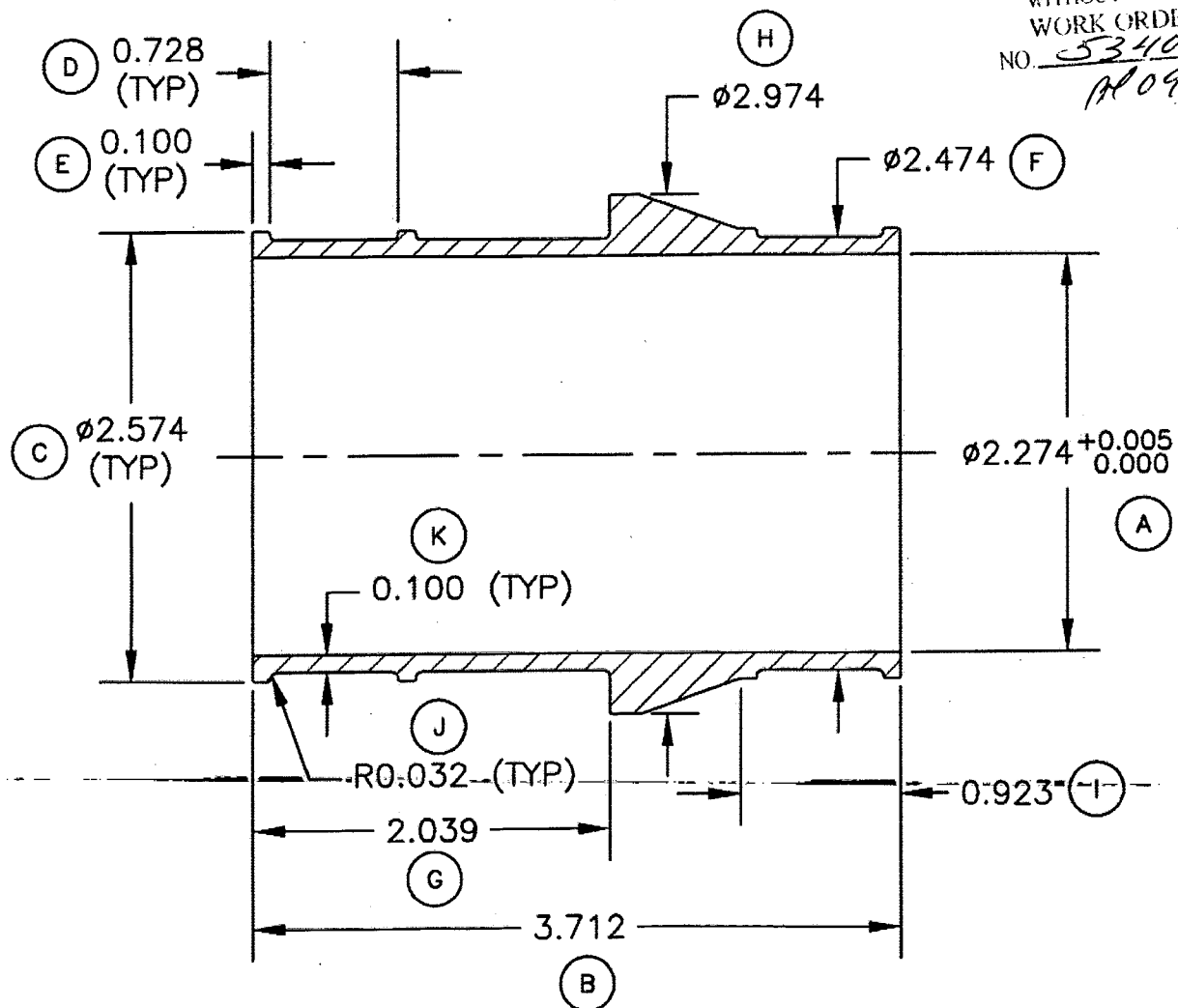
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|--|---|
| A | 08.04.22 | New Issue | KJ/JLM  |  |

DART

| | | | |
|------------------|----------------|---|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED AF | APPROVED AF | DRAWING NO. DSK 076 | REV. A SHEET 1 OF 1 |
| DATE 03.05.20 | | TITLE TURNING DETAIL FOR D2891-1 | SCALE 1:1 |
| A | 03.05.20 | NEW ISSUE | |

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8.07.01 AF

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NO. 53400
AL09-11-3

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